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# **EUROPEAN PATENT APPLICATION**

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(54) Polymeric tetrafluoroethylene compositions and articles, and processes for preparing said compositions.

(57) A fluoropolymer coating composition comprising a mixture of a thermoplastic TFE/PPVE copolymer, and granular PTFE or an amorphous thermoplastic polymer such as polyether imide or polyether sulfone, in a solvent or dispersion is described as being useful to make tetrafluoroethylene polymeric laminates, the thermoplastic copolymer constituting from 50 to 90% of the combined weight of the copolymer and the PTFE or amorphous thermoplastic polymer. An extrudable powder composition comprising a mixture of a thermoplastic TFE/PPVE copolymer and an amorphous thermoplastic polymer is also described.

EP 0 391 568 A2

# POLYMERIC TETRAFLUOROETHYLENE COMPOSITIONS AND ARTICLES, AND PROCESSES FOR PREPARING SAID COMPOSITIONS

This invention relates to polymeric tetrafluoroethylene compositions, to processes for making them, to layered reinforced polymeric tetrafluoroethylene articles, and to particular applications of the layered articles.

The use of fluorocarbon polymer coatings for covering surfaces of objects or for impregnating objects is known. The good heat resistance of tetrafluoroethylene polymers combined with their resistance to solvent attack and their inertness to attack by most chemical agents makes such polymers useful as coatings or impregnants in a wide variety of applications.

Fluoropolymer compositions for spray coating are described in United Kingdom Patent 2,051,091. These compositions utilize the so-called paste extrudable, dispersion-type polytetrafluoroethylene (PTFE) resin, which, as described at page 812 of Kirk-Othmer Encyclopedia of Chemical Technology, volume 9, 2nd Ed., Interscience Publishers, Inc., MY, 1966, is virtually a chemically distinct species from the so-called granular class of PTFE resin. In fact, U.K. Patent 2,051,091, at page 1, column 116 and page 2, lines 32-34, specifically states that paste extrudable "PTFE dispersion powders" are required. The patent, in addition, also states at page 1, line 118-119, that "PFA-powder" can be present and that some granular PTFE can be used as a reinforcing additive (page 2, lines 90-93). "PFA powder" as used therein refers to thermoplastic copolymers of tetrafluoroethylene and perfluoropropyl vinyl ethers (TFE/PPVE) where the content of PPVE and molecular weight of the copolymer are such that normally non-thermoplastic homopolymer PTFE is made thermoplastic. While this patent states that its spray coatings can surround a reinforcing mat, the mat is pressed into a coating already applied to a substrate. The sole substrate class described in the patent is a hard metallic substrate or a glass substrate. It would be desirable to provide a thermoplastic tetrafluoroethylene polymeric composition for use in providing a spray coating that can be used to coat flexible substrates.

U.S. Patent 3,981,945 describes coating compositions of a fluorocarbon polymer and aromatic polysulfones, such as polyethersulfones. But there is no specific disclosure of thermoplastic tetrafluoroethylene copolymers, and all the examples are directed to use of homopolymer polytetrafluoroethylene, which is nonthermoplastic.

Furthermore, examination of Example 5 of the patent and a comparison of it with the other Examples indicates that the aromatic polysulfones are present to improve adherence of the PTFE monopolymer to a hard nonporous substrate. It would be desirable to provide a thermoplastic tetrafluoroethylene polymeric composition for other uses.

It is particularly desirable to provide a thermoplastic tetrafluoroethylene composition for use in making free standing laminated articles of tetrafluoroethylene.

This invention provides a coating composition comprising a mixture of a thermoplastic copolymer of tetrafluoroethylene and perfluoro(propylvinylether), and an amorphous thermoplastic polymer, the thermoplastic copolymer constituting from 50 to 90% by weight of the combined weight of the copolymer and the amorphous polymer.

The composition may be in the form of a sprayable coating composition or an extrudable coating composition.

The mixture may be present in a compatible organic solvent, such as methylene chloride, or as a dispersion in water to provide a sprayable composition. Alternatively the mixture may be in the form of a powder suitable for extrusion processing, such as in the extrusion coating of electrical wire.

Preferably the amorphous thermoplastic polymer is an aromatic polyether sulfone or a polyether imide.

The invention also provides a process for preparing a coating composition which comprises:

(a) dissolving an amorphous thermoplastic polymer in an organic solvent compatible with said polymer,

(b) mixing in a thermoplastic copolymer of tetrafluoroethylene and perfluoro(propylvinyl ether) until the content of the thermoplastic polymer is from 50 to 90 percent by weight of the total weight of the copolymer and the polymer; and

(c) either driving off the organic solvent to leave an extrudable powder mixture, or driving off the organic solvent and dispersing the copolymer mixture in water.

The invention further provides layered composites comprising:

(a) a base first layer of a fluoropolymer composition,

(b) a second layer which is a reinforcing material, and

(c) a third layer on the second layer which is a fluoropolymer composition, said fluoropolymer

composition of the first and third layers comprising a mixture of a tetrafluoroethylene/perfluoro-(propylvinylether) thermoplastic copolymer, and either an amorphous thermoplastic polymer, such as an aromatic polyether sulfone or polyether imide, or polytetrafluoroethylene of the granular class, the thermoplastic copolymer constituting from 50 to 90% by weight of the combined weight of the copolymer and the amorphous polymer or polytetrafluoroethylene.

The reinforcing material may be a fibrous material or unsintered polytetrafluoroethylene tape.

The invention further comprises a process for preparing the layered composites, and processes for using the layered composites.

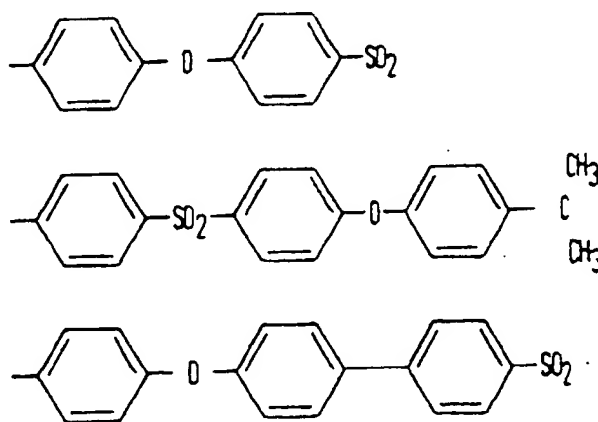
The invention will now be described with reference to a number of examples and to the accompanying drawings in which:-

Figure 1 is a perspective view of a three layer laminate in accordance with the invention,

Figures 2,3 and 4 are perspective views of various pipe laminates in accordance with the invention.

The coating composition of the invention comprises a mixture of 50-90 weight percent of a thermoplastic copolymer of tetrafluoroethylene and perfluoro (propylvinyl ether) and, complementally, 50-10 weight percent of an amorphous thermoplastic polymer, such as polyether sulfone or polyether imide (which may be referred to hereinafter as "polyethers"). The thermoplastic copolymer is sometimes referred to herein as "TFE/PPVE" copolymer; the perfluoro(propylvinyl ether) is sometimes referred to as PPVE; and the polyether sulfone is sometimes referred to as PES. Preferred ranges of amounts in the mixture are 60-80% TFE/PPVE copolymer and 40-20% polyethers. Presence of the thermoplastic copolymer provides the usual heat and chemical resistivity of fluoropolymers to the coating produced from the composition, while presence of the polyethers provides rigidity and stiffness to the coating. The preferred polyether is PES.

TFE/PPVE copolymers are available commercially. E.I. duPont de Nemours manufactures two grades, called Teflon (registered trade mark) PFA, a 340 and a 350 grade. The higher molecular weight grade is preferred. PES is available from ICI plc. The polyether sulfones are aromatic and representative structures include



or sulphur analogs and the like. Preferably, lower molecular weight PES polymers are used because of their compatibility with solvents.

To prepare the coating compositions of the invention, the polyether is dissolved in an organic solvent compatible with the polyether such as methylene chloride, dimethyl formamide, N-methyl pyrrolidone, 1,1,2-trichloroethylene, tetrahydrofuran, or the like. The TFE/PPVE is then stirred in while agitating the solution. The mixture is preferably tumbled, and the solvent is then driven off, usually by heating. The resulting mixture can then be used as an extrudable composition or it can be dispersed in water for use as a spray coating composition.

If TFE/PPVE and PES are mixed dry and then dispersed in water, it has been found that on spray coating, the resulting coating contains clumps or "islands" of PES in the TFE/PPVE matrix. It is necessary to first dissolve the ingredients in the methylene chloride in order to attain a coating that is substantially a uniform mixture, i.e., is substantially free of clumps of PES.

Fillers may be added to the aqueous dispersion to impart specific properties to the coating. For example, as will be elaborated on further below, one use of the layered composite of the invention is as a pipe or hose, especially piping in aircraft fuel lines. When so used, it is necessary for the piping to be conductive in order to dissipate static electricity. It is beneficial, then, in such an end use to add carbon black to the dispersion in order to provide a carbon-black filled conductive coating. Pigments may be added

for coloring. Other additives may be added as specific end uses come to mind to one skilled in the art.

The other coating composition which may be used in preparing layered composites of the invention comprises a mixture of 50-90 weight percent of the thermoplastic TFE/PPVE copolymer described above and, complementally, 50-10 weight percent of granular polytetrafluoroethylene (PTFE). There are several  
 5 types of tetrafluoroethylene polymers, each of which are considered by those skilled in the art to be virtually separate, distinctive classes of chemicals because of their vast difference in properties. One class is called PTFE dispersion powder. It is made by a dispersion polymerization process. It is not a thermopolymer and must be paste extruded. Another class is called PTFE granular powder. It is made by an in situ precipitation process. It is not a thermopolymer either, but it cannot be paste extruded. It must be ram extruded. A third  
 10 separate class is thermoplastic TFE copolymers. As recited further above the PTFE used herein with the thermoplastic PFA copolymer is the granular class of PTFE.

The layered compositions of the invention can be used to provide a reinforced polymeric tetrafluoroethylene article. Figure 1 represents the layered composite in its simplest form. In Figure 1, 10  
 15 represents the base layer of fluoropolymer composition, 11 represents the second layer of reinforcing material laid down on the base layer. 10 represents the third layer, which is composed of the fluoropolymer composition.

The fluoropolymer compositions that may form the base layer and the third layer have been described above. The particular fluoropolymer composition used can be the same or different for each layer.

The reinforcing material is preferably a fibrous material and can be a woven or non-woven material, a  
 20 mesh, or the like. It can be in the form of a fabric, a filament winding, chopped strands, a mat, a roving, or the like. Because a number of end uses of the layered composites require that the composites be in the form of a pipe in which the base layer is the interior surface of the pipe, and because such end uses require that sections of pipe be bonded together, it is convenient to join sections simply by heating the thermoplastic fluoropolymer and melt bonding sections. However, to maintain the integrity of the reinforcing  
 25 layer composition, it is preferable that the fibrous reinforcing material be composed of fibres that have a melting point above the melting point of the thermoplastic fluoropolymers used in fluoropolymer compositions. Such fibrous materials include polyimide fibres such as those known as Kevlar (registered trade mark) polyimide fibres, heat-resistant glass fibres, polytetrafluoroethylene homopolymer fibres, (especially PTFE fibres made of microporous expanded PTFE), polyether ether ketones and the like. The fibrous materials  
 30 can also include carbon fibres, aluminium silicate fibres and other inorganic fibres.

Alternatively, the reinforcing material may be unsintered polytetrafluoroethylene tape. Such tape, made from tetrafluoroethylene homopolymer is available commercially.

In a preferred embodiment, the layered composite is in the form of a pipe or tube in which the layers comprise coaxial layers with the base layer forming the interior of the pipe. The pipe is most conveniently  
 35 made by spraying the base layer fluoropolymer composition on a mandrel, or cylindrical former, made usually of stainless steel and being preferably between 1 and 3 inches in diameter. As illustrated in Figure 2 which depicts a layered pipe composite, the pipe comprises a base layer 10 of fluoropolymer composition. Once the base layer 10 has been sprayed on to the cylindrical mandrel, fibrous reinforcing material 11 is applied. To make a pipe construction, it is convenient to simply wrap a woven or non-woven fibrous material  
 40 around the mandrel, or to simply wind a filament or yarn around the coated mandrel, as shown in the cutaway section of Figure 2. Alternatively, unsintered PTFE tape may be used instead. As a third layer, additional fluoropolymer composition 12 is sprayed on to the reinforcing material 11.

At this point, the layered pipe composite can be removed from the mandrel, if desired. It is a flexible assembly suitable for use as piping or conduit for electrical wiring.

45 To make a stronger, stiffer but still flexible pipe, additional layers of fluoropolymer material and reinforcing material can be added. The order of addition is not critical. However, when the pipe will be used to transport fluids, especially pulsing fluids, it is desirable to use a yarn or filament as layer 11 and to wind it at an angle to the longitudinal axis of the pipe, as shown in Figure 3. An angle of about  $54^\circ$  to the longitudinal has been found preferable. This structure is shown in Figures 3 and 4. Once the first layer of  
 50 fibrous material is laid on, two variations for additional layers are shown in Figures 3 and 4. In Figure 3, after yarn or filament 11 is wound on, fluoropolymer coat 12 is sprayed on, and then to provide strength against pulsing fluids, yarn or filament 13 is wound on in the opposite direction from winding 11. Preferably the direction of winding of 13 is about  $90^\circ$  from the direction of winding of 11. In Figure 4, an alternative is seen in that counterwind 13 is laid on right after winding 11, without an intervening spray coat of the fluoropolymer composition. After winding 13 is laid on, spray coat fluoropolymer composition 14 is sprayed  
 55 on. Figure 4 is broken off at this point, but any sequence of layers may continue if desired. In Figure 3, after fluoropolymer coat 14 is applied, a layer of glass roving 15 is wound on to provide increased rigidity, the roving being applied at an angle of nearly  $90^\circ$  from the longitudinal axis of the pipe. Finally, Figure 3

depicts a final coat of the fluoropolymer composition denoted as 16.

It has been observed that the fluoropolymer composition of thermoplastic copolymer and granular PTFE is removed from a stainless steel mandrel more easily than the other fluoropolymer of the copolymer and PES, and thus the former composition is preferred as base coat 10.

5 A preferred fibrous reinforcing material is yarn or filament made of expanded microporous polytetrafluoroethylene because it provides light-weight, yet unusually strong, reinforcing properties to the layered composite.

Once the finished pipe has been removed from the mandrel, it can be stabilized by subjecting it to heat, e.g. 150°-260° C.

10 One embodiment of the layered pipe composition finds use in fuel systems and electrical conduit systems of aircraft. The advantages of using PTFE assemblies in aircraft are well known. PTFE liners provide chemical resistance and good high temperature performance. However, PTFE liners must be sufficiently thick to avoid collapse from negative pressure, and the thickness hinders freedom of movement. The piping embodiment of the present invention provides fluoropolymer composition coatings thin enough  
15 to permit flexibility of the piping, particularly the flexing incurred in aircraft wings. Moreover, airframes of aircraft do not use nearly as much metal as heretofore, so that a fuel system made of metal piping acts as a lightning conductor and could be the cause of severe damage to, or destruction of, an aircraft in the event of a lightning strike. The same applies to metallic electrical conduits, especially when they run through fuel tanks. A degree of conductivity is necessary, however, to allow static electric charges to be dissipated. The  
20 piping composites described herein are particularly suited for such use in aircraft when the fluoropolymer composition layers contain carbon black to provide a degree of conductivity to dissipate static electricity. Being thermoplastic, the fluoropolymer layers can be bent in installation to fit particular aircraft configurations.

## EXAMPLES

### 30 Example 1

This Example illustrates preparation of a coating composition in accordance with the invention and a layered composite using the composition. A solution in methylene chloride was made by adding 30gm of polyether sulfone to 100milliliters of methylene chloride and then stirring in 70gm of a thermoplastic  
35 copolymer of tetrafluoroethylene and perfluoro (propoylvinyl ether). The methylene chloride was driven off by heating at 80° C in an oven. An aqueous dispersion of the resulting mixture was then made up by mixing the mixture in 100gm of water.

The dispersion was sprayed on a stainless steel mandrel about 30mm in diameter until the coating had a thickness of about 10mils. It was dried at about 100° C for about 30 minutes and then baked by raising  
40 the temperature to 350° C for about 30 minutes.

Then a fibre of expanded microporous polytetrafluoroethylene (available from W.L.Gore & Associates, Inc. as RASTEX [registered trade mark] sewing thread) having a denier of about 1200 was wound around the sprayed mandrel at an angle of about 54.5° and heated at 350° C for 30 minutes to stabilize the thread.

Next, the same dispersion of fluoropolymer composition as used for the base coat was sprayed on the  
45 wound assembly until a thickness of 5mils was obtained. The composite was baked as before. Then another layer of the same fibre sewing thread was wound on at 54.5° in the other direction and stabilized as before.

A final layer of the same fluoropolymer dispersion as used for the base layer was then sprayed on to a thickness of about 10mils, and a final baking treatment was carried out as described above.

The resulting pipe assembly was checked for leakage by filling it with water and pressurizing it to  
50 250Psi. No pinhole leaks were seen.

### Example 2

55 This example illustrates preparation of a coating composition and a layered composite in accordance with the invention using the composition.

A solution in methylene chloride was made by adding 30gm of polyether sulfone to 100 milliliters of methylene chloride and then stirring in 30gm of granular polytetrafluoroethylene and 70gm of a thermoplas-

tic copolymer of tetrafluoroethylene and perfluoro(propylvinyl ether). The methylene chloride was driven off by heating at 80° in an oven. An aqueous dispersion of the resulting mixture was then made up by mixing the mixture in 100gm of water.

The resulting dispersion was sprayed on the same mandrel as used in Example 1 to the same thickness and dried and baked as in Example 1. The same fibre sewing thread was then wound on and heat treated as in Example 1. The same dispersion as used for the base coat was then sprayed on and baked as in Example 1 and then another winding of the same sewing thread was put on, as in Example 1. A final coat of the same dispersion as used for the base layer was sprayed on to a thickness of 10mils, and a final baking carried out as Example 1. The resulting pipe was tested for pinhole leaks as in Example 1. No leaks were found.

### Example 3

This example illustrates preparation of a layered composite in accordance with the invention.

A dispersion in water of a thermoplastic copolymer of tetrafluoroethylene and perfluoro(propylvinyl ether), and granular polytetrafluoroethylene (PTFE) was prepared by adding 75gm of the copolymer and 25gm of the PTFE to 110gm of water containing a binder of carboxyl methyl cellulose.

The resulting dispersion was sprayed on the same mandrel used in Example 1 to the same thickness and dried and baked as in Example 1. After cooling, another 5 mils was sprayed on and baked in the same manner. The same fibre sewing thread was then wound on and heat treated as in Example 1. The same dispersion as used for the base coat was then sprayed on and baked as in Example 1 and then another winding of the same sewing thread was put on, as in Example 1. Another sprayed layer was put on until a 5 mil thickness was obtained, and over that a 10 mil diameter PTFE coated glass fibre thread was wound on substantially perpendicularly to the mandrel axis. A final coat of the same dispersion as used for the base layer was then sprayed on to a thickness of about 10mils, and a final baking carried out as in Example 1.

The resulting pipe was tested for pinhole leaks as in Example 1. No leaks were found. The pressure was then increased until the pipe burst. The bursting pressure was in excess of 400 p.s.i.

### Example 4

This example illustrates preparation of an extrudable coating composition in accordance with the invention.

200 gms of polyether imide (PEI) powder (Utem 1000) was dissolved in one litre of methylene chloride and the solution added slowly over a period of 15 minutes to 2.0 kilograms of TFE/PPVE copolymer powder (Teflon PFA 350) of maximum particle size 180 microns in a suitable mixer. The mixer was run for a further 15 minutes after the addition of the solution, during which time the mixer was heated to 75° C to accelerate the evaporation of methylene chloride.

At the end of the mixing cycle the blend was removed from the mixer and dried for eight hours at 120° C. The material was then thermoplastically extruded onto 22 AWG silver plated copper wire to give a 0.25 mm thick coating of insulation. Dynamic cut-through, abrasion resistance and fluid resistance properties of the coated wire were measured in accordance with BS G 230, and the results are given in Table 1.

### Comparison example (compared with Example 4)

2.0 kg of TFE/PPVE copolymer (Teflon PFA 350) powder of maximum particle size 180 microns was blended with 200 gm of PEI powder (Utem 1000) of maximum particle size 180 microns in a high speed powder blender (Fielder blender) for thirty minutes. The resultant blend was dried for eight hours at 120° C to remove moisture and then thermoplastically extruded onto 22 AWG silver plated copper wire to give a 0.25 mm thick coating of insulation. The dynamic cut-through, abrasion resistance and fluid resistance properties of the coated wire were measured in accordance with BS G 230, and the results are given in Table 1.

In the following Table 1, the results obtained from Example 4 and its comparison example are also compared with results obtained from a wire insulated with virgin TFE/PPVE copolymer (Teflon PFA 350).

Table 1

	Dynamic Cut Through Load	Scrape Abrasion Resistance	Fluid Resistance
	(N)	(Cycles to Failure)	
Example 4	78.1	370	Pass
Comparison Example	40.0	41	Fail
Virgin PFA	40.0	50	Pass

### Claims

1. A coating composition comprising a mixture of a thermoplastic copolymer of tetrafluoroethylene and perfluoro(propylvinylether), and an amorphous thermoplastic polymer, the thermoplastic copolymer constituting from 50 to 90% by weight of the combined weight of the copolymer and the amorphous polymer.
2. A composition according to claim 1 wherein the amorphous polymer is an aromatic polyether sulfone or a polyether imide.
3. A composition according to claim 1 or claim 2 including an organic solvent in which the components of the mixture are soluble.
4. A composition according to claim 1 or claim 2 wherein the mixture is dispersed in water.
5. A composition according to claim 1 or claim 2 wherein the mixture is in the form of a powder.
6. A process for preparing a composition according to claim 4 which comprises:
  - (a) dissolving an amorphous thermoplastic polymer in an organic solvent compatible with said polymer;
  - (b) mixing in a thermoplastic copolymer of tetrafluoroethylene and perfluoro(propylvinyl ether) until the content of the thermoplastic copolymer is from 50 to 90 percent by weight of the total weight of the copolymer and the polymer;
  - (c) driving off the organic solvent; and,
  - (d) dispersing the copolymer mixture in water.
7. A process for preparing a composition according to claim 5 which comprises:
  - (a) dissolving an amorphous thermoplastic polymer in an organic solvent compatible with said polymer;
  - (b) mixing in a thermoplastic copolymer of tetrafluoroethylene and perfluoro(propylvinyl ether) until the content of the thermoplastic copolymer is from 50 to 90 percent by weight of the total weight of the copolymer and the polymer; and,
  - (c) driving off the organic solvent to leave an extrudable powder mixture.
8. A process according to claim 6 or claim 7 wherein the organic solvent is methylene chloride.
9. A layered composite comprising:
  - (a) a base first layer (10) of a fluoropolymer composition,
  - (b) a second layer (11) of a reinforcing material; and,
  - (c) a third layer (10';12) of a fluoropolymer composition; said fluoropolymer composition of each of said first and third layers comprising a mixture of a thermoplastic copolymer of tetrafluoroethylene and perfluoro(propyl- vinyl ether) and either an amorphous thermoplastic polymer or polytetrafluoroethylene of the granular class, the thermoplastic copolymer constituting from 50 to 90% by weight of the combined weight of the copolymer and the amorphous polymer or polytetrafluoroethylene.
10. A layered composite according to claim 9 wherein the reinforcing material (11) is a fibrous material.
11. A layered composite according to claim 9 wherein the reinforcing material (11) is unsintered polytetrafluoroethylene tape.
12. A layered composite according to any one of claims 9 to 11 wherein the amorphous thermoplastic polymer is an aromatic polyether sulfone or polyether imide.
13. A layered composite according to any one of claims 9 to 12 wherein a fourth layer (13) of fibrous reinforcing material is present.
14. A layered composite according to claim 13 wherein a fifth layer (14) of said fluoropolymer



composition is present.

15. A layered composite according to claim 14 wherein a sixth layer (15) of fibrous reinforcing material is present.

5 16. A layered composite according to claim 15 wherein a seventh layer (16) of said fluoropolymer composition is present.

17. A layered composite according to any one of claims 9 to 16 wherein the composite is in the form of a tube.

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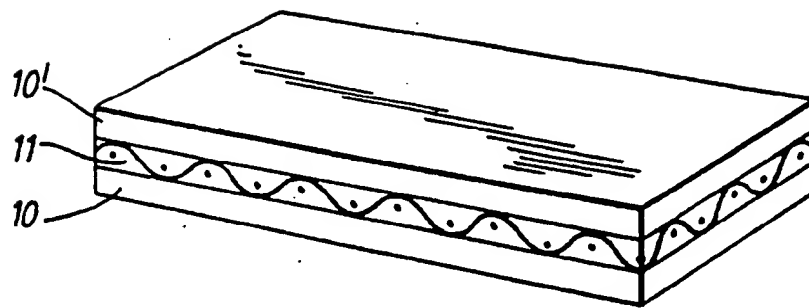
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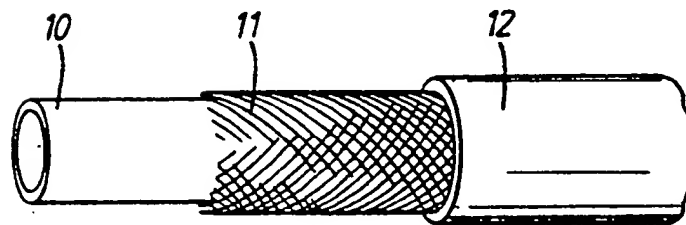
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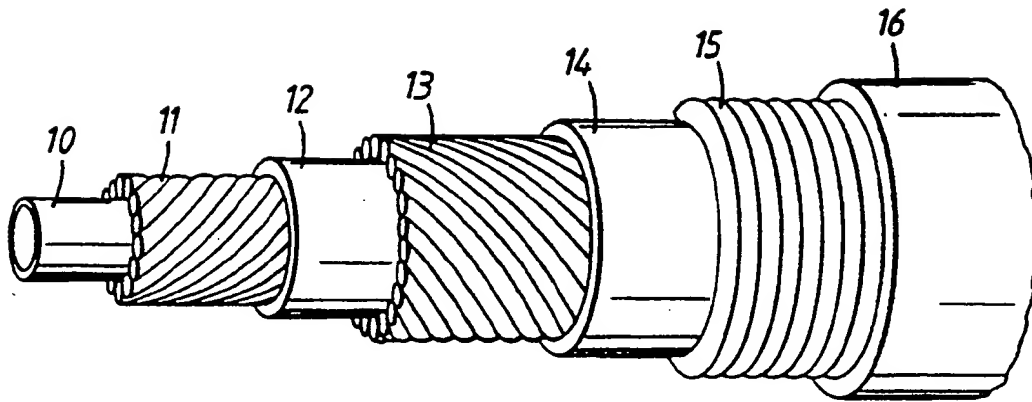
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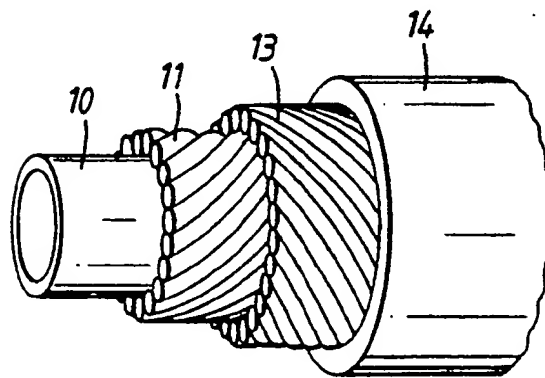
*Fig.1.*



*Fig.2.*



*Fig.3.*



*Fig.4.*

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# EUROPEAN SEARCH REPORT

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## DOCUMENTS CONSIDERED TO BE RELEVANT

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
A	<u>EP - A1 - 0 100 889</u> (HOECHST AKTIENGESELLSCHAFT) * Claims 1,11 * --	1,2,4, 9,11	C 09 D 127/18 C 08 L 27/18 C 08 L 79/08 C 08 L 81/06
A	<u>EP - A1 - 0 159 767</u> (SUMITOMO CHEMICAL COMPANY, LIMITED) * Claims 1,5 * --	1,2,5	B 32 B 27/28 C 09 D 127/20
A	<u>US - A - 4 703 076</u> (MORI) * Claim 1 * --	1,2	
A	<u>US - A - 4 655 944</u> (MORI) * Claim 1 * --	1,9,11	
A	<u>EP - A2 - 0 301 543</u> (SUMITOMO ELECTRIC INDUSTRIES LIMITED) * Claim 1; abstract * ----	1,17	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B 32 B 27/00 C 08 L 27/00 C 08 L 71/00 C 08 L 79/00 C 08 L 81/00 C 09 D 127/00
The present search report has been drawn up for all claims			
Place of search VIENNA		Date of completion of the search 18-11-1991	Examiner PUSTERER
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